



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7810

Job Sheet 205063



Part No: 647.7810

Job Qty: 8 pcs

Part Name: Bracket A



Part Weight: 0 lbs

Job Created: 12/27/19

Due Date: 2/21/20

Type: Stock

Note: DWG REV A IPP Rev: A RQ 15.08.06 Verified by DD

Ship Via:

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run		Workcenter/Supplier	Sign-off
					Hrs	Hrs		
100	Bandsaw - 1	8 pcs	2/21/20	2/21/20	0.00	0.25	Bandsaw - 1	KT 2020-03-18
110	HAAS 4 Axis - B4B	8 pcs	2/21/20	2/21/20	0.30	6.84	HAAS - 1 - B4B	
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
120	QC 2	8 pcs	2/21/20	2/21/20	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S264443



Part: 647.7810

Job No: 205063

Serial No/Batch: S264443

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/18/20

130 QC 8	8 pcs	2/21/20	0.00 0.00	QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	12 20-3-26
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
131 Handfinish - 2-1 Pressure- B4B 8 pcs	8 pcs	2/21/20	0.00 0.67	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
140 Outsource - 4 - Anodize	8 pcs	2/21/20		ATG001-VC	8
150 Packaging 2-1 - Receive - B4B 8 pcs	8 pcs	2/21/20	0.00 0.00	Packaging 2 - 1 - B4B	14 2020-03-27
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	14 MAY 07 2020
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	

				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
155 QC 6	8 pcs	2/21/20	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	8 pcs	2/21/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
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				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	

DAS
40
MAY 27 2020
9-89

DAS
28
9-89

190 QC 21 - SA	8 pcs	2/21/20	0.00 0.00	Packaging 3 - 37 - B4B	
				QC 21 - SA - 21	DAS
				QC 21 - SA - 70	MAY 28 2020 70
				QC 21 - SA - 53	9-89

Part Op 100 - (Bandsaw) Cut Blank at 10.313"

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB408
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 131 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings)
 140 - Issue P/O to ATG : 46189 Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A
 150 - (Receive & Inspect for Damage & Mat'l Certs)
 155 - (QC6- All purchased or subcontracted products)
 180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
 190 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M7075T6S6.000X0.250	7075-T6S Sheet 6" Thick Plate X 0.25" Wide	6.8720 ft (.859 ea)	100-Bandsaw - 1	<u>S255358</u>

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S6.000X0.250	7	1	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket A	0.090inches $\pm$ 0.005	0.095 0.085	.087	
2	Bracket A	45.000inches $\pm$ 0.500	45.500 44.500	45°	
3	Bracket A	0.255inches $\pm$ 0.005	0.260 0.250	.250	
4	Bracket A	9.810inches $\pm$ 0.010	9.820 9.800	9.810	
5	Bracket A	0.260inches $\pm$ 0.010	0.270 0.250	.250	Radius
6	Bracket A	29.900Degrees $\pm$ 0.500	30.400 29.400	29.9°	Angle
7	Bracket A	3.671inches $\pm$ 0.005	3.676 3.666	3.672	
8	Bracket A	16.900Degrees $\pm$ 0.500	17.400 16.400	16.80°	Angle
9	Bracket A	9.463inches $\pm$ 0.005	9.468 9.458	9.463	
10	Bracket A	100.000Degrees $\pm$ 0.500	100.500 99.500	100°	Angle
11	Bracket A	18.700Degrees $\pm$ 0.500	19.200 18.200	18.6°	Angle
12	Bracket A	9.092inches $\pm$ 0.002	9.094 9.090	9.0915	
13	Bracket A	3.332inches $\pm$ 0.002	3.334 3.330	3.332	
14	Bracket A	7.300inches $\pm$ 0.002	7.302 7.298	7.2995	
15	Bracket A	0.397inches $\pm$ 0.002	0.399 0.395	.397	
16	Bracket A	2.575inches $\pm$ 0.002	2.577 2.573	2.575	
17	Bracket A	2.475inches $\pm$ 0.002	2.477 2.473	2.4755	
18	Bracket A	0.500inches $\pm$ 0.002	0.502 0.498	.5005	
19	Bracket A	0.400inches $\pm$ 0.002	0.402 0.398	.3995	

Plex 12/27/19 12:44 PM Dart.lajeunesse.marie

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube Machining ☐ Large Fab ☐ Cross tube Small Fab ☐ Finishing ☐ Eng. (Non-AW) Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering Water Jet ☐ Supplier ☐ Quality ☐		Date: _____ Sequence #: _____ QTY Affected: _____		MRB (QS1042)																									
Description Work Order Deviation				Disposition																													
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐				FAULT CATEGORY																													
				<table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread
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Marks/Chatter	Drill Holes	Out of Sequence	Misread																														
Mislabeled	Fit/Function	Off-set/Set-up																															
Other/Details: _____				Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____																													



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046189



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046189

PO Date: 3/27/20

Due Date: 4/13/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197648	647.1912	647.1900 Rev N/C	Bracket LH : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O: Black Anodize as per Dwg 646.3800	Firmed X10	-	4/13/20	10 pcs	0 pcs	10 pcs	\$10.48/pcs	\$104.80
									APR 15 2020			
2	207950	RBEL135M-2905-101-09	RBEL135M-2905-101 Rev 9	Drive Pulley Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) -Issue PO -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed X4	-	4/13/20	4 pcs	0 pcs	4 pcs	\$6.98/pcs	\$27.92
									APR 15 2020			
3	208136	C10-21-2	C10-21-2 Rev 2	Spring Cover -Issue P/O -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed X20	-	4/13/20	20 pcs	0 pcs	20 pcs	\$6.98/pcs	\$139.60
									APR 15 2020			

Plex 3/31/20 12:58 PM Dart.Guerin.Kimberley



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Hawkesbury, ON
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Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046189



Items												
Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	216064	647.7811	647.7800 Rev A	Bracket B : Various STC's Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed X8	-	4/13/20	8 pcs	0 pcs	8 pcs	\$16.28/pcs	\$130.24
								MAY 07 2020				
5	205063	647.7810	647.7800 Rev A	Bracket A : Various STC's Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed X8	-	4/13/20	8 pcs	0 pcs	8 pcs	\$16.28/pcs	\$130.24
								MAY 07 2020				
6	205053	647.1611	647.1600 Rev A	Wiper Deflector, Aft : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG :	Firmed X2	-	4/13/20	20 pcs	0 pcs	20 pcs	\$12.48/pcs	\$249.60
								APR 15 2020				
Grand Total:												\$782.40

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 3/31/20 12:58 PM Dart.Guerin.Kimberley



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 920096

Date: 06-May-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
8 ea	Part: 647.7811 BRACKET B Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 5265778 Job: 27243 PO: POHB046189	Rev: A Expiry Date: 08/21 Line: 4	
8 ea	Part: 647.7810 Bracket A Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 5265778 Job: 27244 PO: POHB046189	Rev: A Expiry Date: 08/21 Line: 5	DAS 40 9-89
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>MAY 06 2020</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Made in Canada.			

RECEIVED

MAY 06 2020

DART AEROSPACE LTD.

